

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004261**Date Inspected:** 20-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shangxing Island, Shanghai

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** Deck panel**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China.. While on site the QA Inspector noted the following:

Deck Panel DP109-001

The QA Inspector performed Ultrasonic Testing (UT) using the gate to gate technique on the partial joint penetration welds made on the U-ribs (four ribs two welds per rib eight welds total) on the deck panel number DP109-001. The ultrasonic testing was being performed on the tack weld areas only a total of 224 tack welds were made on the eight welds. (Please see summary of conversations below). The QA Inspector performed the testing on the weld number one and eight. (Please see note below). The QA Inspector observed a total of twenty indications on the welds and the indications were marked on the steel for phased array ultrasonic testing investigation that will be perform at a later time. The QA Inspector completed the testing on the two welds at this location on this date. Please see the QA Inspector's log generated on this date for additional information regarding the amount of indications observed and locations.

NOTE: The QA Inspector could not perform the testing on these welds at the full extend due to the fact that the ZPMC personnel were performing fabrication next to QA Inspector's working area. The QA Inspector notified Task Leader Robert Cuellar of discrepancy during testing.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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### Summary of Conversations:

The QA Inspector was notified by Task Leader Robert Cuellar the ZPMC personnel performed Magnetic Particle testing on the total tack welds made on the u-ribs prior to complete the partial joint penetration welds, reported multiple relevant indications, the indications found were removed by grinding and the welding was completed.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann (1500) 2219-9593, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Medina,Ricardo
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert
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QA Reviewer
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